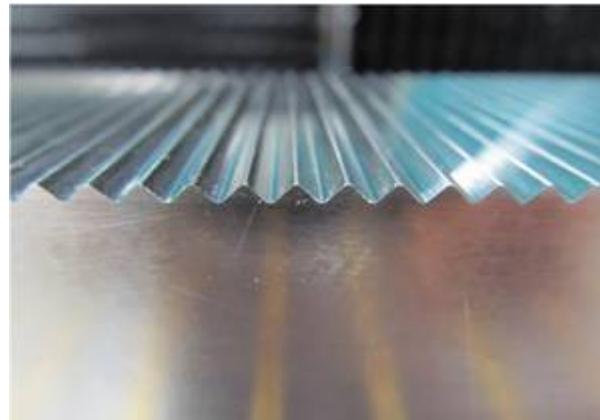
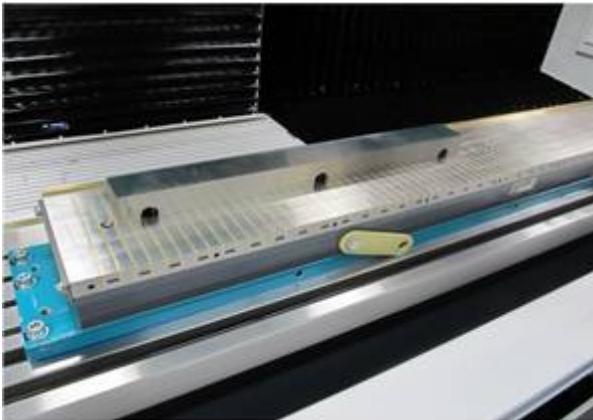


Rolling Rack

A12-830



-Pitch is very well

-Tooth ground and tooth width needs more experienced data

-If the basic form of the tools are not exactly straight, the measurement results from a measuring machine are very difficult to interpret, or not useable.

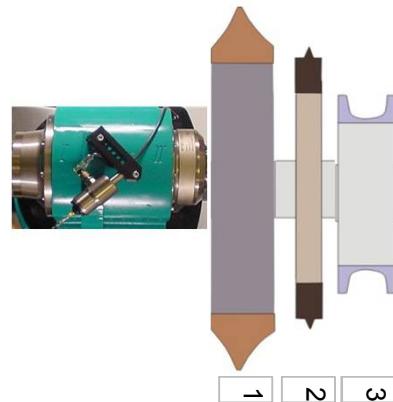
1. Cycletime for Resharpening

Workpiece:	Width 60mm; height 45mm length 609mm							
Material HSS								
Operations	Probe	Dress	Profile Rgh	Profile Fin	Dress	Top Radius	Dress	Back Radius
Feed [mm/Min]	2000	80	250	250	80	1000	80	2000
Power [kW]		1	5	1	1	1	1	1
Cutting speed [m/s]		10	30	30	15	35	15	35
Used wheels		1	1	1	1	2	3	3
Grinding time [min]	0	45	125	145	15	25	5	40
Total cycle time	6h 40min							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø200 B126
2	DXF Ø200 C280
3	DXF Ø200 C280



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : CORVUS BBA

Control: Fanuc 31A5

Accessories:

Responsible engineer: LIM, 14.05.2014

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5.4.6

**TECHNOLOGY
FOR TOOLING**